

Work Order ID 114728

March-11-14 2:53:39 PM

split
(24)

114728

Page 1

Item ID: D4653-11

Revision ID:

Item Name: Clamp

Start Date: 12/03/2014 Start Qty: 36.00

Required Date: 12/03/2014 Req'd Qty: 36.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 14-03-12 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4653

A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK AT 3.025"

0.00

36

8

MH 14/03/26

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER DWG & FOLIO FB119

FOLIO REV: AA

DWG REV: A

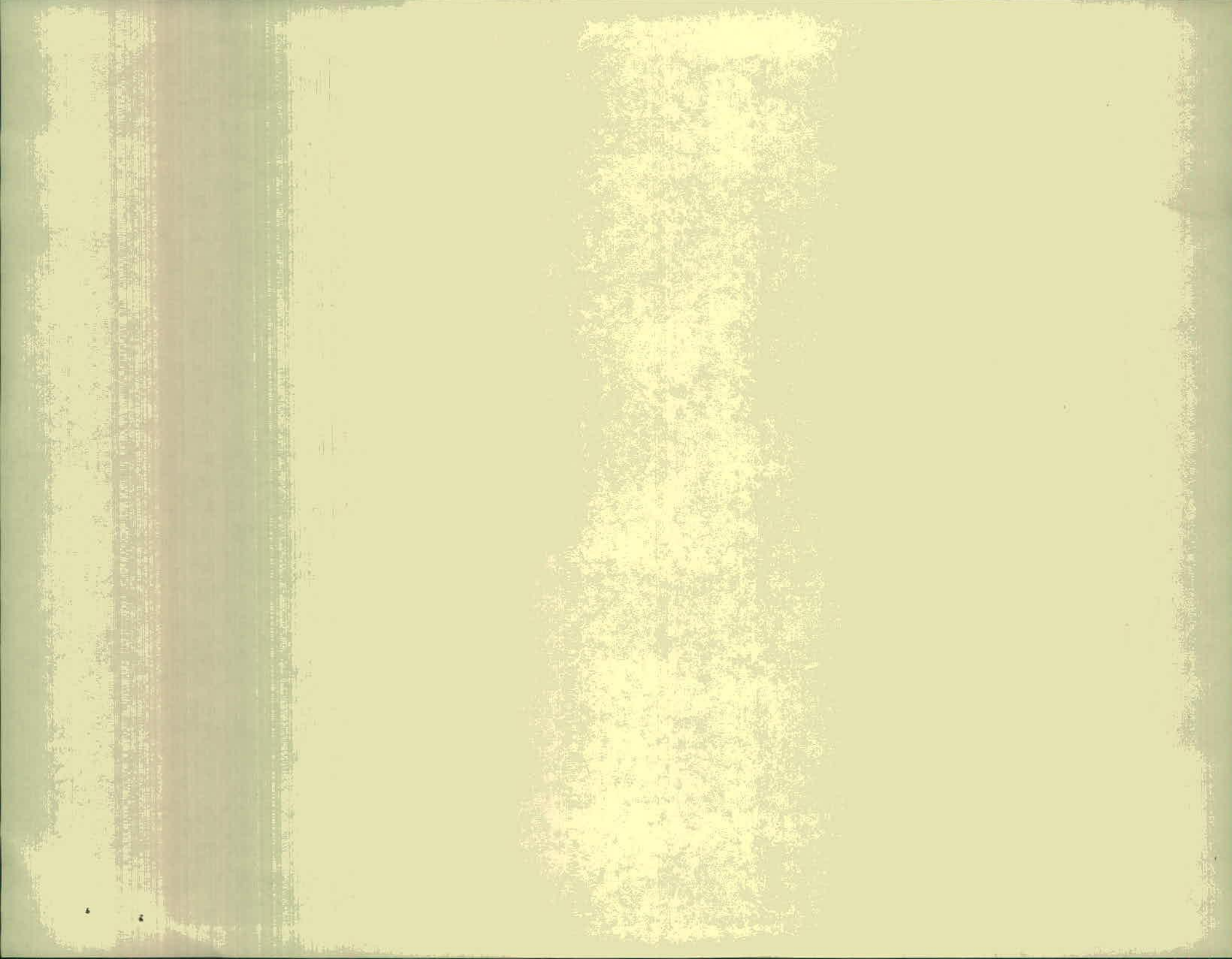
0.00

24

0

JFC 2014-03-27

DEBURR



March-11-14 2:53:39 PM

Page 2

Packaging

1-10
08
040

Work Order ID 114728

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114728

Page 3

Item ID: D4653-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp
 Start Date: 12/03/2014 Start Qty: 36.00 *36* Cust Item ID:
 Required Date: 12/03/2014 Req'd Qty: 36.00 *36* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21 - Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

14-03-31

(A) 14-03-31

Picklist Print

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Page 329

Work Order ID: 114728

114728

Parent Item: D4653-11

D4653-11

Parent Item Name: Clamp

Start Date: 12/03/2014

Required Date: 12/03/2014

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP REV:A 12/06/12 NEW ISSUE JFS VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELINB1.00X04.0 00		Purchased	No			100	f	22.0000	0.252	10			

MDEI RINB1 000X04 000

Delrin Bar

**

Location

Loc Qty

Loc Code

MAT038

22

124382

6

m128113

16

4.53

MH 14/03/20

DART AEROSPACE LTD	Work Order: 114728
Description: CLAMP	Part Number:
Inspection Dwg: D4653-11 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.20	+/- 0.03	1.200 1.200	✓		Caliper	Caliper JFL-01
R1.08	"	1.075	✓			
R1.45	"	1.4475	✓			
0.38	"	0.378	✓			
0.28	"	0.290	✓			
15°	+/- 0.01	15°	✓		Ang depth t	Ang t Shop JFL-07
0.015x45°	+/- 0.01	0.015x45°	✓			
R0.032	+/- 0.01	R0.032	✓			
0.02x45°	+/- 0.03	0.02x45°	✓			
0.03x45°	"	0.03x45°	✓			
R0.03	"	R0.03	✓		Rad t	Shop JFL-01
0.12	"	0.122	✓		Caliper	
0.13	"	0.130	✓			
0.06	"	0.065	✓			
0.10	"	0.100	✓			
0.85	"	0.852	✓			
0.55	"	0.551	✓			
2.25	"	2.250	✓			
0.13	"	0.130	✓			
0.30	"	0.301	✓			
0.10	"	0.100	✓			
0.14	"	0.136	✓			
0.15	"	0.150	✓			

Measured by: JFL	Audited by: D.A. DAS 08 9-89	Preliminary Approval:
Date: 2014-03-27	Date: 14/03/28	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

22
d12
7

DART AEROSPACE LTD	Work Order:	114728
Description: CLAMP	Part Number:	
Inspection Dwg: D4653-11 Rev: A		Page 1 of 1

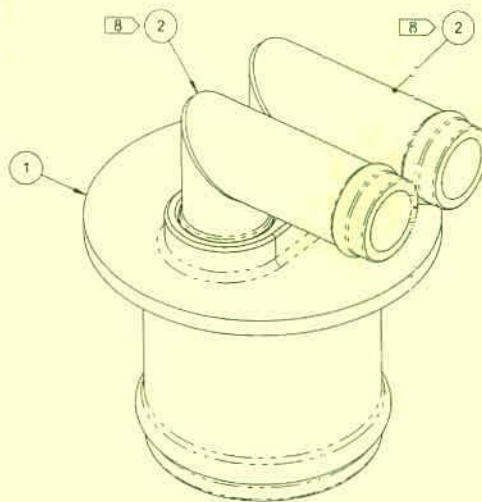
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: JFC	Audited by:	Preliminary Approval:
Date: 2014-03-27	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4653-041 VENT MANIFOLD ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4653-041	VENT MANIFOLD ASSEMBLY
1	1	D4653-3	COLLAR
2	2	D4653-045	FITTING ASSEMBLY
3	A/R	LUBRICANT	MOLKOYE 55 O-RING GREASE

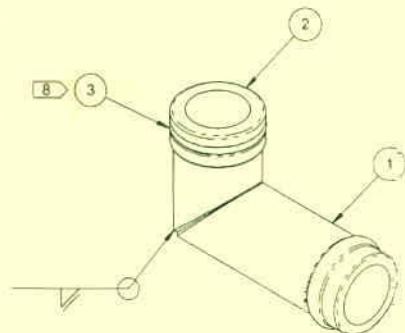
114728 NP
14-03-12

RELEASED
2012-11-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.35 lbs
- 8) APPLY A LAYER OF MOLYKOTE 55 O-RING GREASE TO O-RING PRIOR TO INSTALLING D4653-045

A	NEW ISSUE	MB	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	HF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HB		
CHECKED	HB	DRAWING NO	REV. A
MFG. APPR.	HB	D4653	SHEET 1 OF 6
APPROVED	HB	TITLE	SCALE
DE APPR.	HB	VENT MANIFOLD ASSY	NTS
DATE	12.07.25	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4653-045 FITTING ASSEMBLY

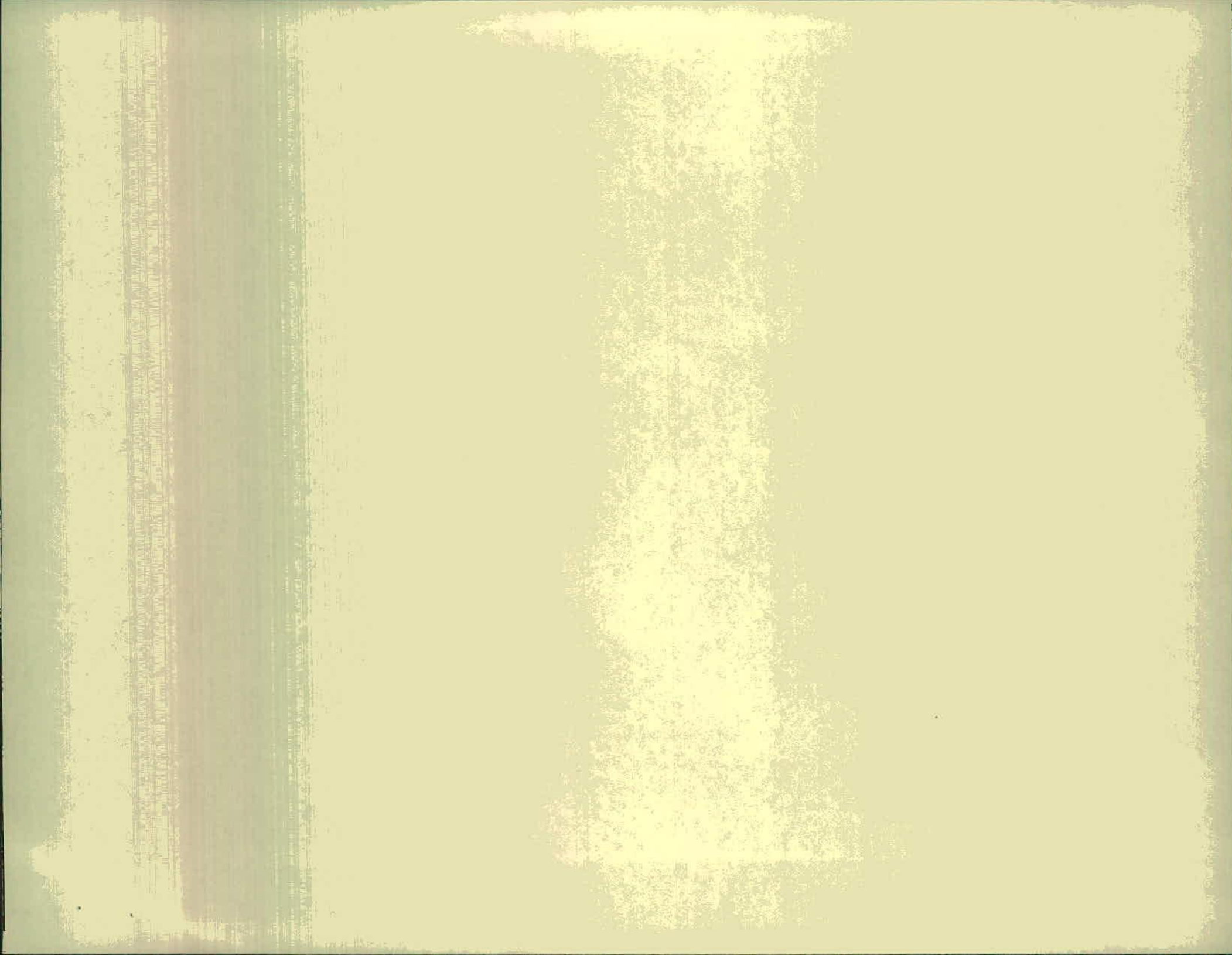
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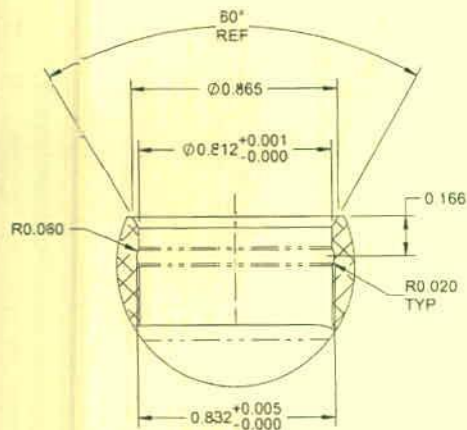
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

ITEM	QTY	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING

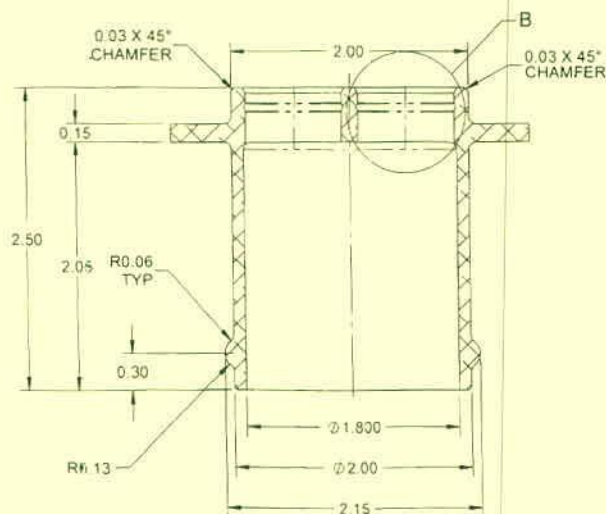
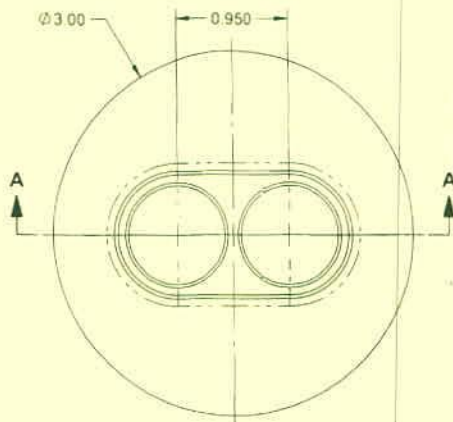
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MFG. APPR.	Y	D4653	SHEET 2 OF 6
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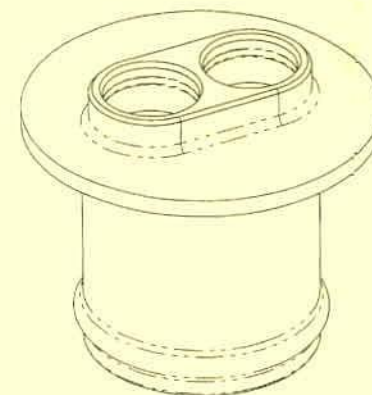




SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



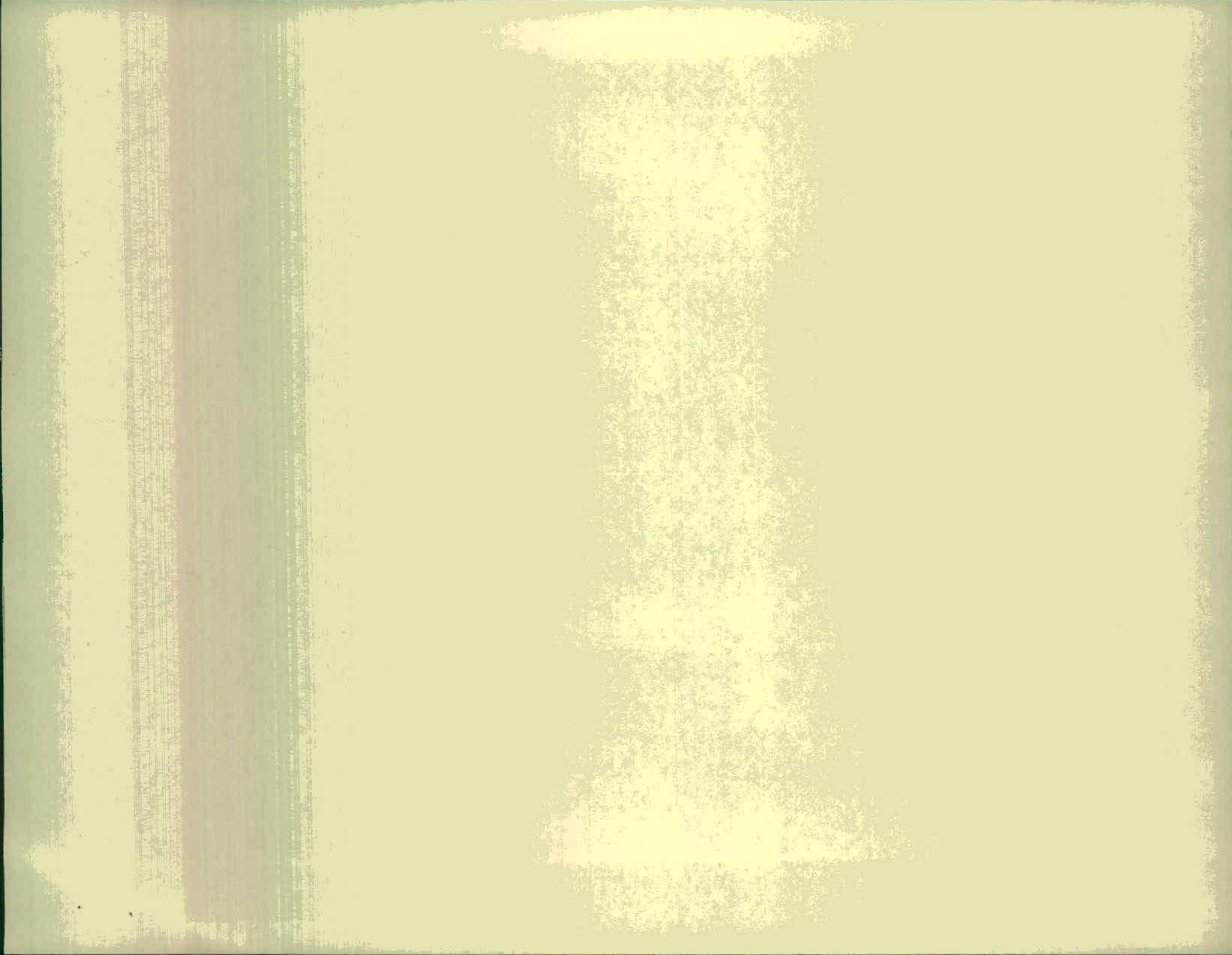
D4653-3 COLLAR

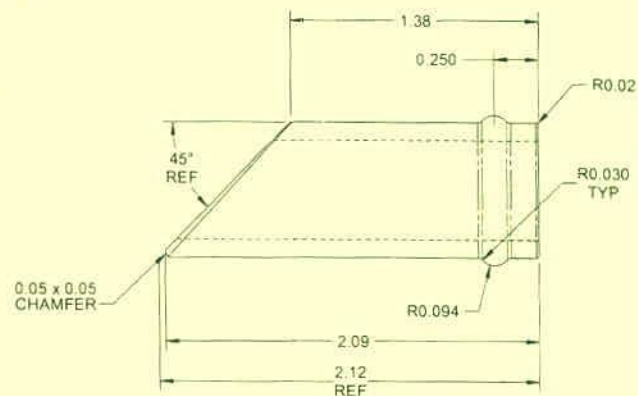
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

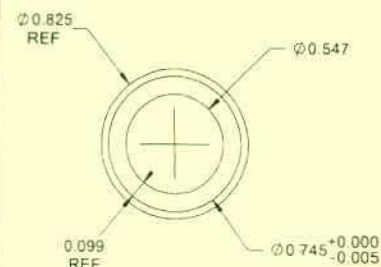
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D4653-7 LARGE FITTING

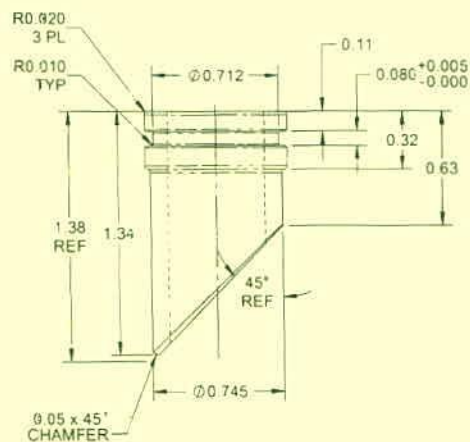
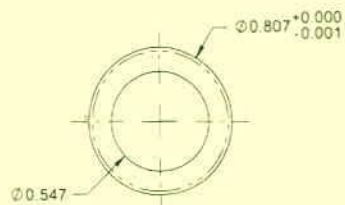


NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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D4653-9 SMALL FITTING

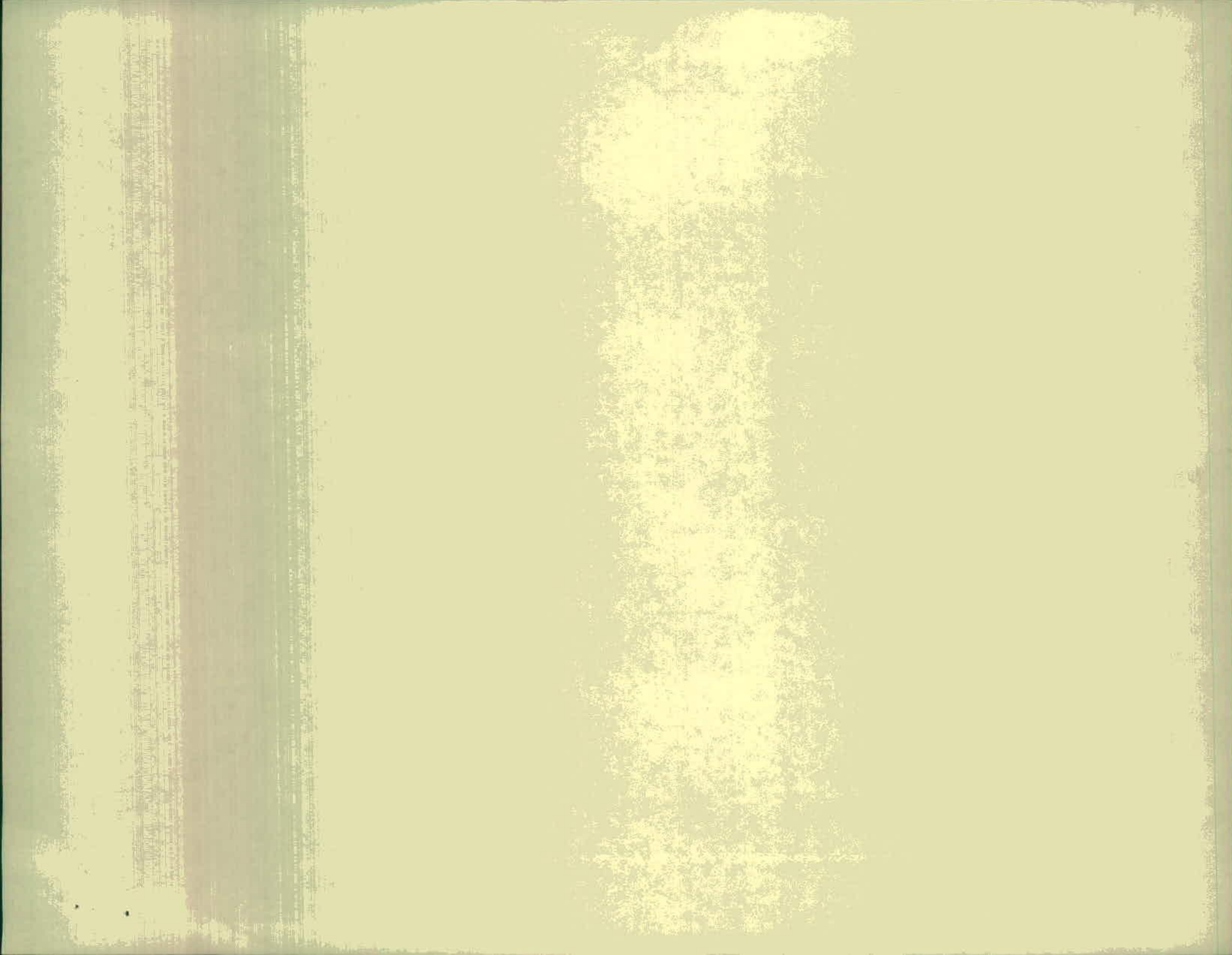


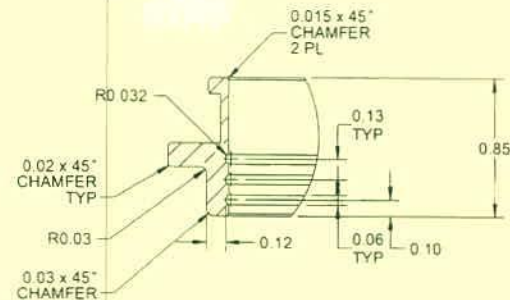
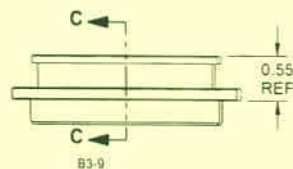
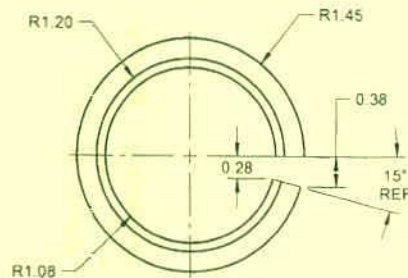
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2012-11-05
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NOTES:
1) MATERIAL 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R

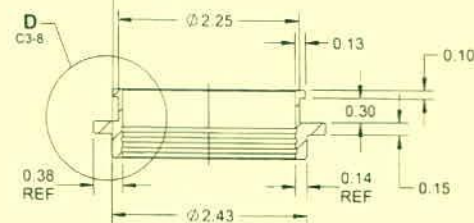
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SYMBOL: ARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

DESIGN	D4653	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS	DRAWING NO	REV. A
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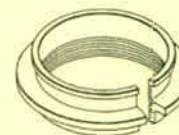




DETAIL D C4-9
SCALE 2X



SECTION C-C C6-9



D4653-11 CLAMP

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.032 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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